

Work Order ID 55610

January 25, 2010 12:44:51 PM



Page 1

Item ID:	D3443-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Strut Weldment Assembly					
Start Date:	1/25/10	Start Qty:	4.00		Cust Item ID:	
Required Date:	2/01/10	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-1-25	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3443								
110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

4

PD 10.01.28

2) 10/01/28

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55610

January 25, 2010 12:44:51 PM

Page 2

Item ID: D3443-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut Weldment Assembly

Start Date: 1/25/10 Start Qty: 4.00

Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

11113170

0.00

=> JU 10-01-28

(X4)

Ø

Powder Coating

Memo

I-Mask holes as per dwg D3443

START TIME: 10:15am

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:45am

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

PR 10-01-28

(4)

Ø

Quality Control

150

Small Fab

0.00



Small Fab

Memo

0.00

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

EP 10/01/28 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 55610

January 25, 2010 12:44:51 PM

Page 3

Item ID: D3443-041

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Item Name: Strut Weldment Assembly

Start Date: 1/25/10 Start Qty: 4.00

Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

=> 8/10/12



QC

Memo

0.00

Quality Control

(X)

170

Identify as per dwg & Stock Location: 198A

0.00



Packaging

Memo

0.00

Packaging

10-1-29 (4) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/02

mf
10-2-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55610

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Date: 1/25/10

Required Date: 2/01/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3443-1		Manufactured	No			100	Each	19.0000	4.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 12

46143 1

51308 11

Main Warehouse

WA 7

53698 7

D3443-5		Manufactured	No			100	Each	8.0000	4.0000			
---------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Tubing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 8

53487 2

53917 6

PL10 01 27

✓ 4

PL10 01 27

✓ 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 25, 2010 12:45:41 PM

Work Order ID: 55610



Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 1/25/10

Required Date: 2/01/10

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3453-1		Manufactured	No			100	Each	28.0000	4.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Clevis

Handwritten: 10 01 27

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	18	
----	----	--

46144	6	
-------	---	--

53732	12	
-------	----	--

Main Warehouse

st92	10	
------	----	--

52986	10	
-------	----	--

D3965-4		Manufactured	No			100	Each	16.0000	4.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Bearing, Spherical

Handwritten: 10 01 28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	16	
----	----	--

53680	16	
-------	----	--

Handwritten: 10 01 28

Handwritten: 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 3

January 25, 2010 12:45:41 PM

Work Order ID: 55610



Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 1/25/10

Required Date: 2/01/10

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3966-4-750

Manufactured No

100

Each

69.0000

8.0000



Pin, Dowel



Handwritten signature
10 01 27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

69

— 53631 —

69

✓ (8)

January 25, 2010 12:45:41 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

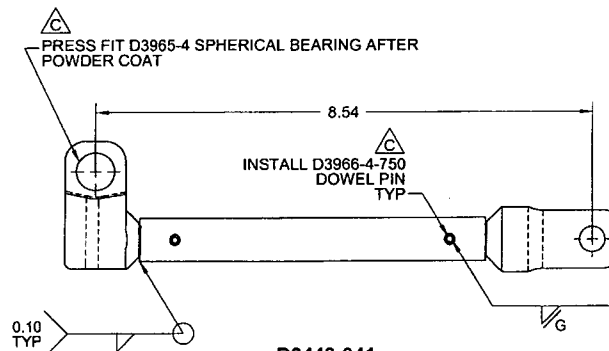
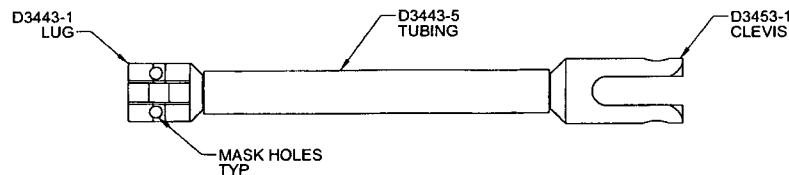
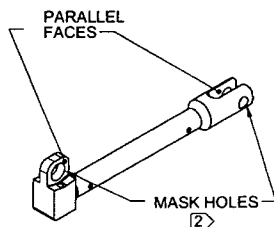
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

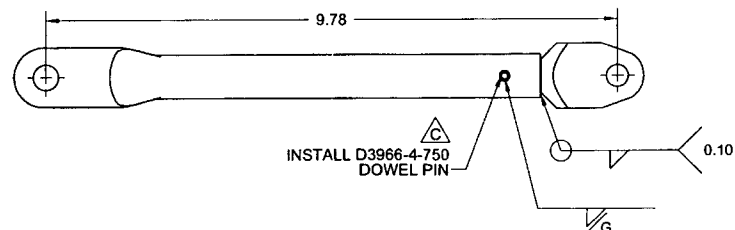
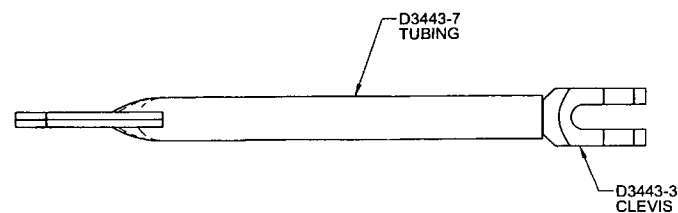
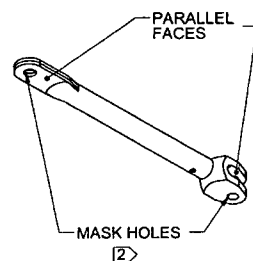
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35610
PRC-1-25

RELEASED
09/08/25 M

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0 219 WAS R0 050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø 0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN




D3443-043

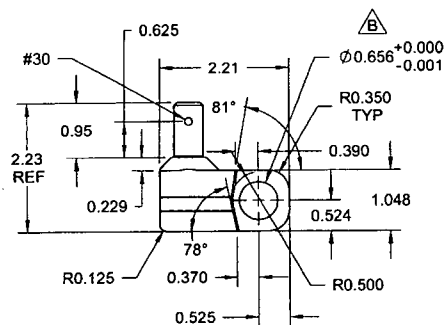
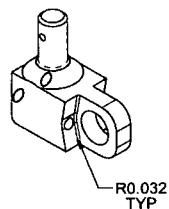
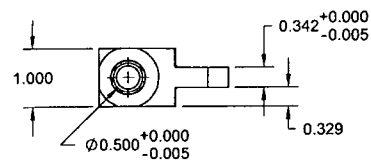
RELEASE
09/08/25/14

NOTES:

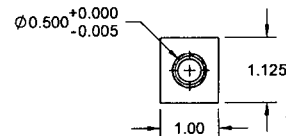
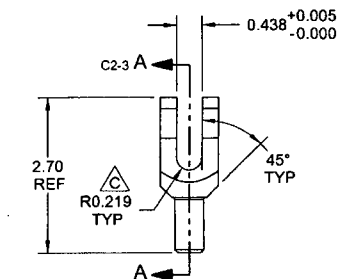
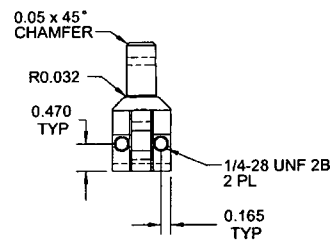
- NOTE:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 NO POWDER COAT IN HOLES
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.97 lbs
 8) WELD PER DART QSI 004

DESIGN	RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF		DRAWING NO. D3443	REV. 0	
CHECKED	RF			SHEET 2 OF 2	
MFG. APPR.					
APPROVED					SCALE
DE APPR.					STRUT WELDMENT ASSEMBLY
DATE		09.06.25			

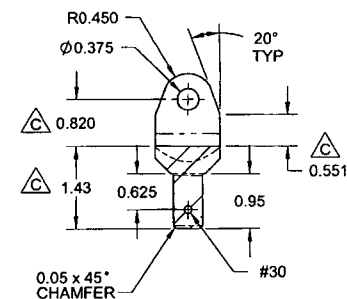
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D3443-1 LUG



D3443-3 CLEVIS



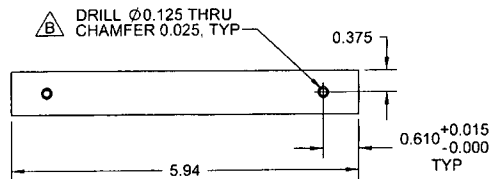
SECTION A-A C4-3

NOTES:

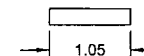
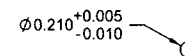
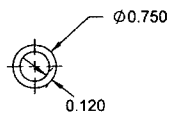
- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

RELEASED
09/06/25/14

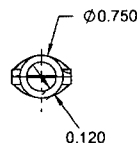
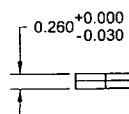
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
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D3443-5 TUBING

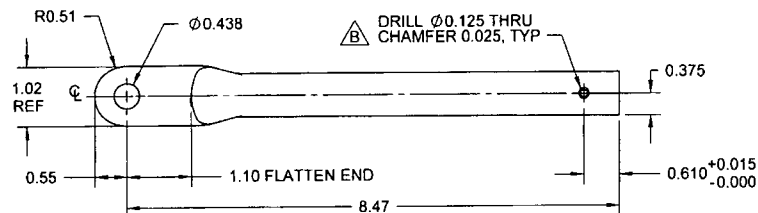


D3443-9 PIN



D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

RELEASED
01/03/25 m

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	